

Date: Monday, 3/6/2006 10:13:08 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 26050	
Estimate Number : 10384	
P.O. Number : N/A	Part Number : D3195043
This Issue : 3/6/2006 S.O. No. : N/A	Drawing Number : D3195 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 25808	Material : N/A
	Due Date : 3/13/2006 Qty: .20 Um: Each
Written By : <u>SEE COMMENT BELOW</u>	
Checked & Approved By : <u>SEE ABOVE USEC &amp; DATE</u>	
Comment : Est Rev:A New Issue 05-11-08 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B1500X01250	6061-T6 Bar 1.5" x 1.25"
Comment: Qty.: 0.3150 f(s)/Unit Total: 6.3000 f(s) Material: 6061-T6/T651 (QQ-A-200/8) or (QQ-A-225/8) or (QQ-A-250/11) (M6061T6B1.250x1.500) Identify for D3195-3 Batch: <u>M16957 (1.500x1.500) x</u> <u>Ep 06/03/06 21</u>		
2.0	BAND SAW	BAND SAW
Comment: BAND SAW Cut blanks: (1.250" x 1.500") x 3.60" long <u>Ep 06/03/06 21</u>		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1  1-Machine D3195-3 as per Folio FA334 and Dwg D3195 Identify as D3195-3  2-Deburr <u>J.F. 06/03/08 20</u>		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>JE 06/03/08 20</u>		
5.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>SA 06.03.08 21</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: BRACKET

Job Number: 26050

Part Number: D3195043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m 06-03-09

(21)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

a.m 06-03-09 (21)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 06 03 09 21

9.0

D31957

Pad



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3195-7

PAD

13 B 25115  
8 B 26059

SB 06/03/13 (21)

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Lightly Sand bonding surface

2-Bond D3195-7 into D3195-13as per Dwg D3195

A/R Contact Cement M 100008

SB 06/03/13 (21)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06 03 13 21

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 134

P 4/3/13 (21)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: LD Date: 26/03/14  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/6/2006 10:13:09 AM  
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Drawing Name: BRACKET

Job Number: 26050

Part Number: D3195043

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
Inspection Level 21

Done 03/14 @

Job Completion



U 0603-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	26050
<b>Description:</b> Bracket		<b>Part Number:</b>	D3195-3
<b>Inspection Dwg:</b> D3195 <b>Rev:</b> A		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.432	+/-0.010	3.434"				
1.265	+/-0.010	1.258"				
R0.37	+/-0.030	R0.370"				
Ø0.277	+0.005/-0.000	Ø0.277"				
2.677	+/-0.005	2.679"				
0.242	+/-0.010	0.247"				
0.377	+/-0.010	0.379"				
0.500	+/-0.010	0.502"				
R0.188	+/-0.010	R0.188"				
0.250	+/-0.010	0.250"				
0.882	+/-0.010	0.878"				
1.250	+/-0.010	1.251"				
0.500	+/-0.010	0.501"				
Ø0.191	+0.005/-0.000	Ø0.191"				
1.000	+/-0.010	1.001"				

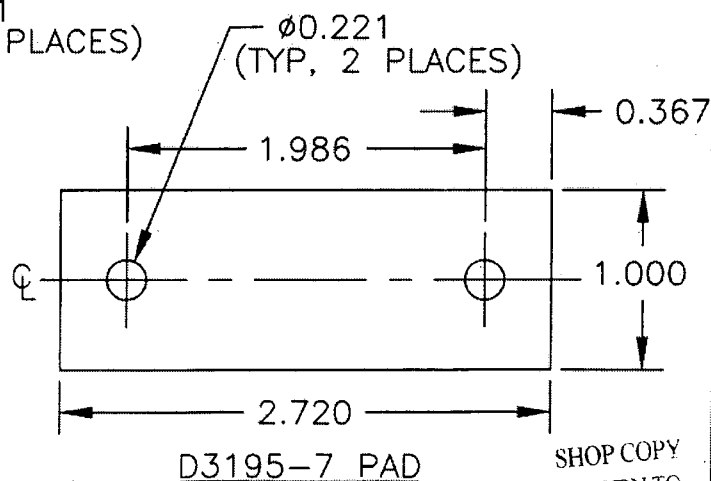
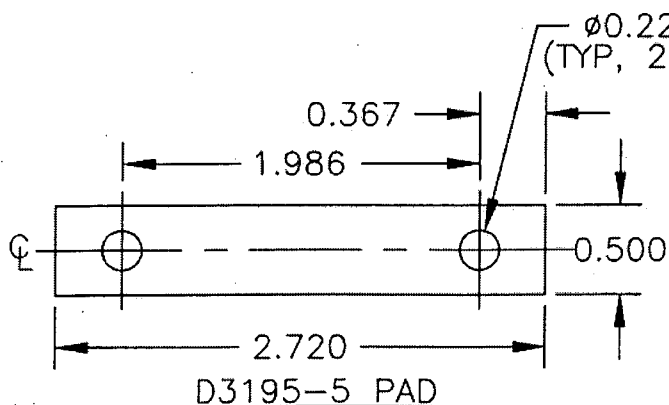
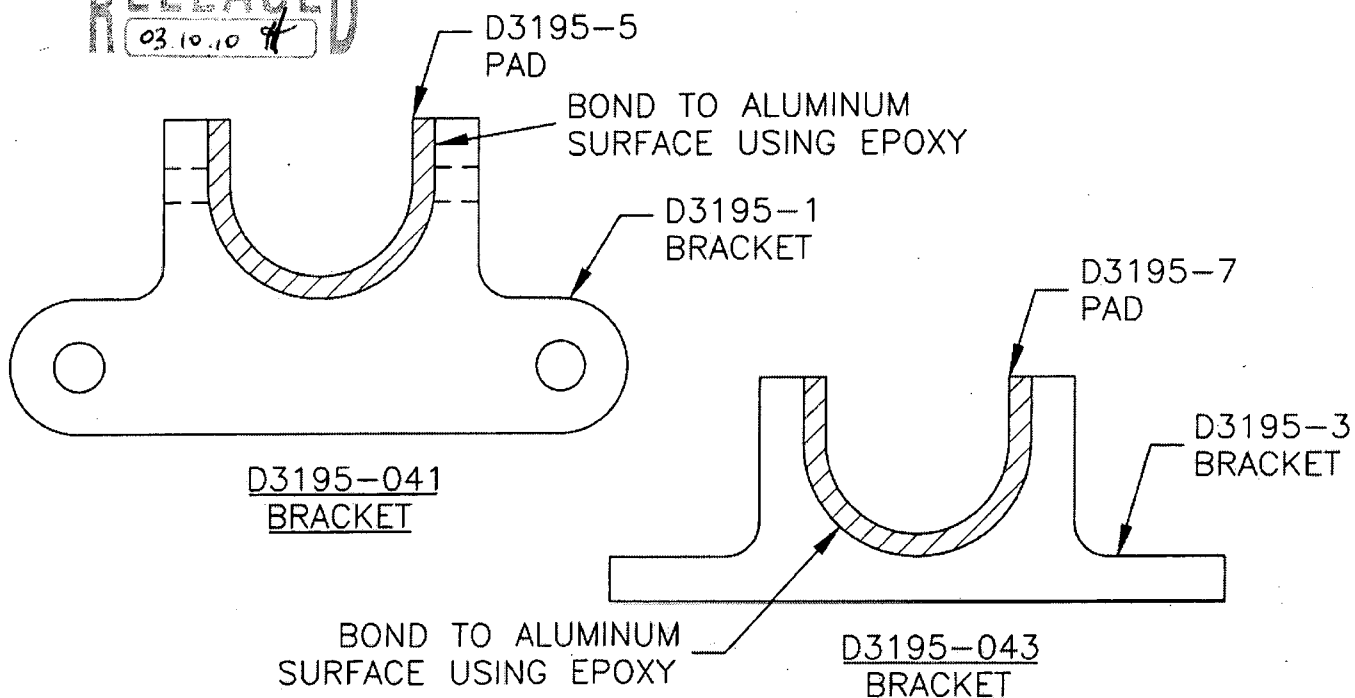
<b>Measured by:</b>	JF	<b>Audited by:</b>	JD	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	06/03/07	<b>Date:</b>	06.03.07	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D412-702-011/-013)	KJ/RF	
B	05.04.26	R0.37 was R0.037; 1.084 removed	KJ/JLM	



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CHECKED	#	APPROVED	#	DRAWING NO. D3195	REV. A SHEET 1 OF 3
DATE	03.06.23			TITLE BRACKET	SCALE 1:1
A	03.06.23			NEW ISSUE	

RELEASED  
03.10.10 #



#### D3195-5 & D3195-7 PAD

- 1) MATERIAL: 60 DUROMETER NEOPRENE 1/8" THICK  
(POSSIBLE SUPPLIERS, ACCURATE RUBBER)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 3) ALL DIMENSIONS ARE IN INCHES

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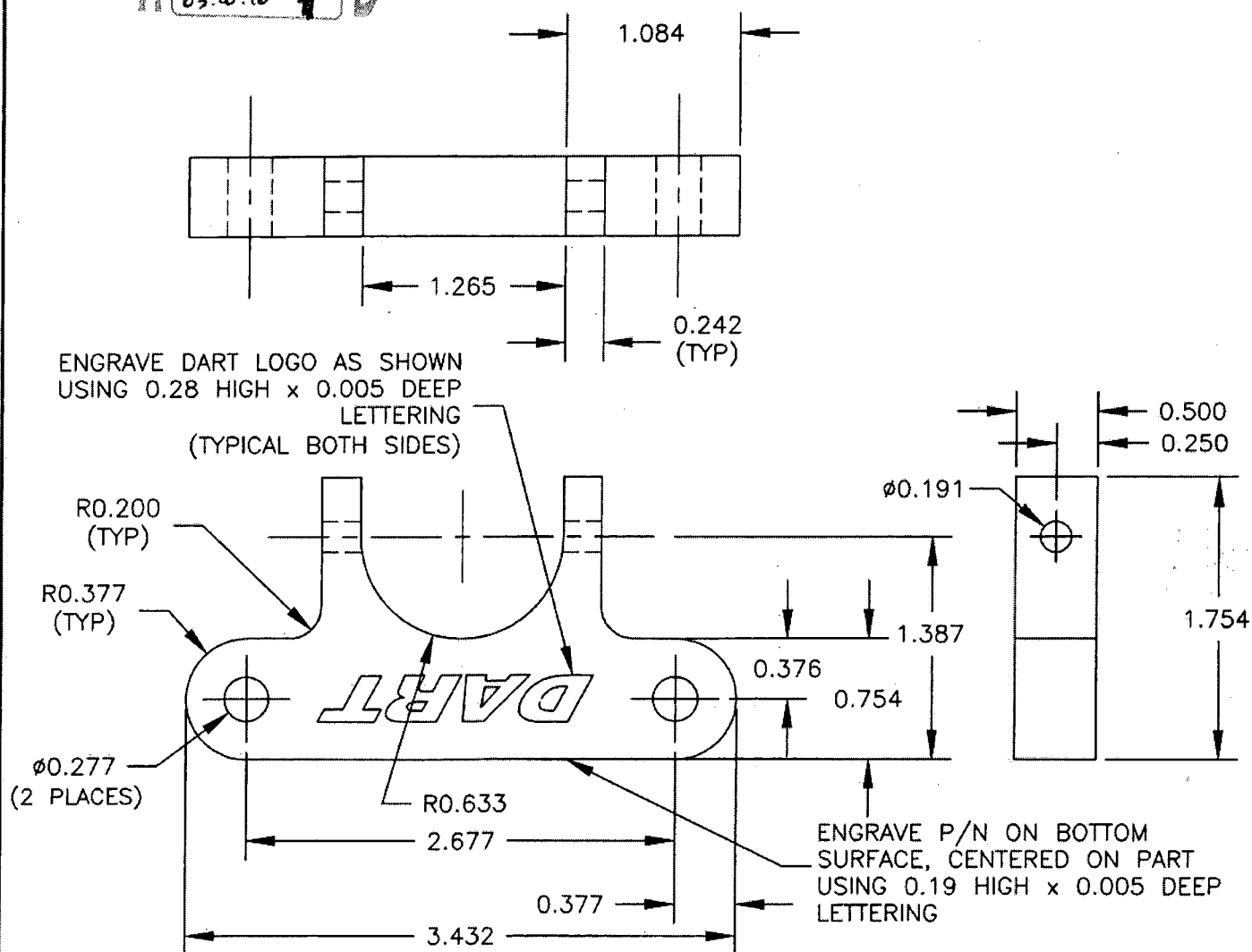
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DATE 03.06.23		TITLE BRACKET	SCALE 1:1

RELEASED  
03.10.10



D3195-1 BRACKET

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)  
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

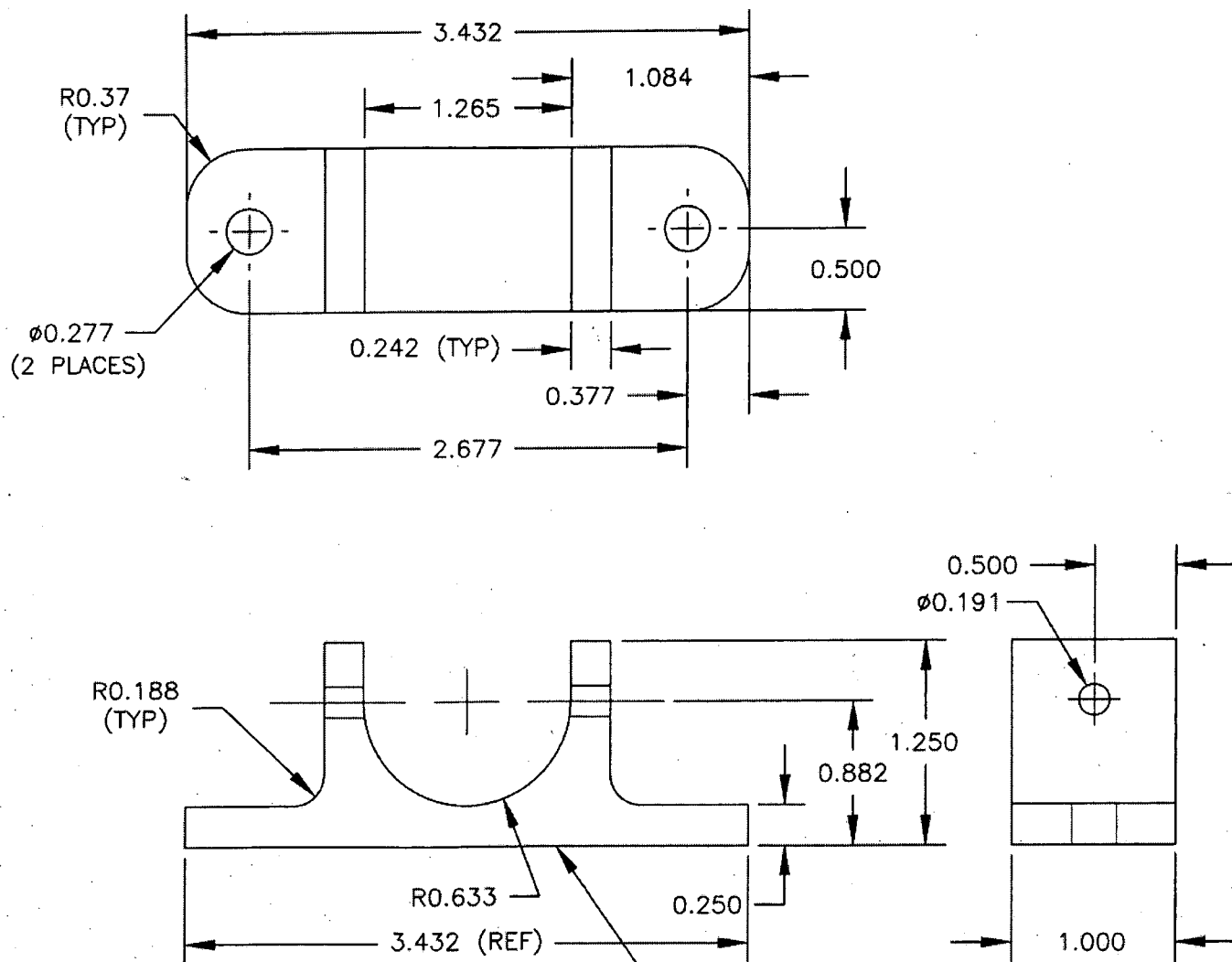
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DATE 03.06.23		TITLE BRACKET	SCALE 1:1



RELEASED  
03.10.10

ENGRAVE P/N ON BOTTOM  
SURFACE, CENTERED ON PART  
USING 0.19 HIGH x 0.005 DEEP  
LETTERING

**D3195-3 BRACKET**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)  
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
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